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“पुराने को छोड़ नये के तरफ”

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“Step Out From the Old to the New”

IS 8919-4 (1978): Specification for Adjustable Adaptors for Tools with Self-Holding Taper Shanks, Part 4: Clamping Nuts
[PGD 32: Cutting tools]

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“Invent a New India Using Knowledge”



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“Knowledge is such a treasure which cannot be stolen”



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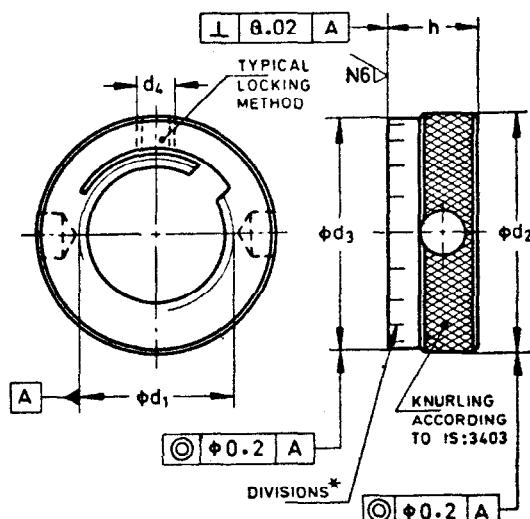
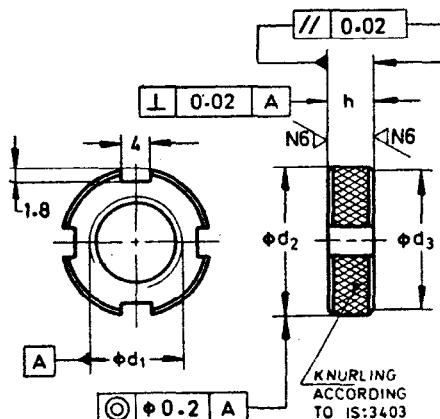
SPECIFICATION FOR ADJUSTABLE ADAPTORS FOR TOOLS WITH SELF-HOLDING TAPER SHANKS

PART IV CLAMPING NUTS

1. Scope — Covers the dimensions and requirements for clamping nuts, used with adjustable adaptors of short, long and extra long type as covered in Parts I to III of this standard.

2. Dimensions

N9/ (N6/)



FOR NOMINAL SIZES 8 TO 12

FOR NOMINAL SIZES 16 TO 48

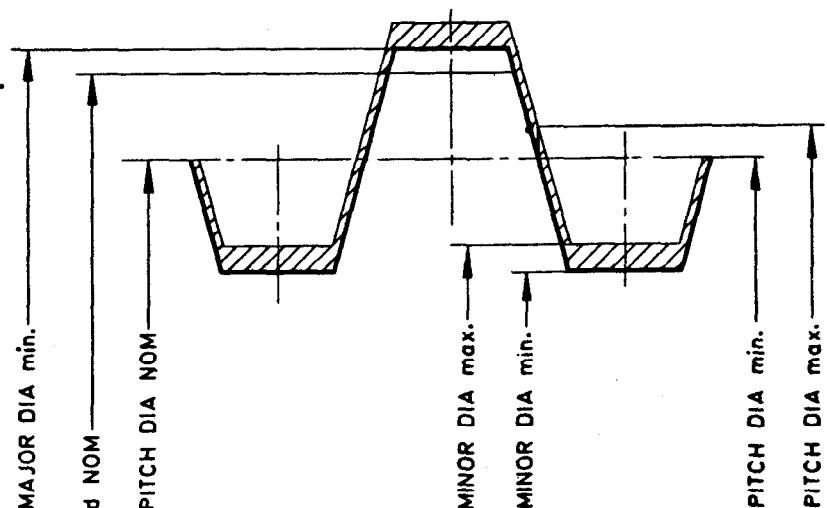
*The spacing of the divisions corresponds to an adjustment of 0.1 mm. Each fifth division shall be made longer.

All dimensions in millimetres.

Nominal Size d ₁ †	d ₁	d ₂		d ₃ h13	d ₄	h
		Basic	Tol			
8	Tr 8×1	14.8	0 -0.2	14	—	5
10	Tr 10×1.5	17.8	0 -0.2	17	—	6
12	Tr 12×1.5	19.7	0 -0.2	19	—	6
16	Tr 16×1.5	24.6	0 -0.4	24	M5	12
20	Tr 20×2	31.6	0 -0.4	31	M6	12
25	Tr 25×2	36.6	0 -0.4	36	M5	12
28	Tr 28×2	39.6	0 -0.4	39	M6	12
36	Tr 36×2	49.6	0 -0.4	49	M6	14
48	Tr 48×2	66.6	0 -0.4	66	M8	18

†As specified in Parts I to III of this standard.

2.1 The limiting dimensions for ISO metric trapezoidal nut threads shall be as under:



All dimensions in millimetres.

Thread Nominal Size	Major Diameter Min	Pitch Diameter		Minor Diameter	
		Min	Max	Min	Max
Tr 8×1	8.200	7.500	7.690	7.000	7.150
Tr 10×1.5	10.300	9.250	9.474	8.500	8.690
Tr 12×1.5	12.300	11.250	11.486	10.500	10.690
Tr 16×1.5	16.300	15.250	15.486	14.500	14.690
Tr 20×2	20.500	19.000	19.265	18.000	18.236
Tr 25×2	25.500	24.000	24.280	23.000	23.236
Tr 28×2	28.500	27.000	27.280	26.000	26.236
Tr 36×2	36.500	35.000	35.230	34.000	34.236
Tr 48×2	48.500	47.000	47.300	46.000	46.236

3. Material — Carbon steel of tensile strength not less than 600 MPa* in the core after case hardening.

4. Hardness — Case hardened to 590 HV to 630 HV, except on threads, which may be left unhardened.

5. General Requirements

5.1 Knurling shall be according to IS : 3403-1966 'Dimensions for knurling'.

5.2 Tolerance on dimensions without specified tolerance shall be of grade 'medium' according to IS : 2102-1969 'Allowable deviations for dimensions without specified tolerance (first revision)'.

6. Workmanship and Finish — The nuts shall be free from cracks, burrs and other manufacturing defects.

7. Sampling — The sampling and criteria of acceptance according to IS : 7778-1975 'Methods for sampling small tools'.

*1 MPa = 0.1 kgf/mm² (approx.).

8. Designation — A clamping nut with trapezoidal thread $d_1=Tr\ 25\times 2$, having set screw and conforming to this standard shall be designated as:

Nut Tr 25×2 IS : 8919 (Part IV)

9. Certification Marking — Details available with the Bureau of Indian Standards.

10. Protective Coating and Packing

10.1 Each nut shall be covered with a suitable rust proofing material.

10.2 Each nut shall be wrapped in a non-absorbent paper protected by a cover bearing the size and manufacturer's name or trade-mark.

10.3 Nuts of one size shall be packed in one carton.

EXPLANATORY NOTE

This standard on adjustable adaptors for tools with self-holding taper shanks is being issued in the following parts:

Part I Short adaptors

Part II Long adaptors

Part III Extra long adaptors

Part IV Clamping nuts for adaptors

In the preparation of this standard considerable assistance has been derived from the following publications:

ISO 2905-1974 ' Modular units for machine tool construction — Spindle noses and adjustable adaptors for multi-spindle heads ' issued by International Organization for Standardization.

DIN 6327 (Sheet 4)-1972 Stellhülsen mit Werkzeugkegel; Nutmuttern und Klemmmuttern (Adjustable adapters for tools with morse taper shanks, adjuster nuts and locking nuts) issued by Deutsches Institut für Normung.